



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3411

Job Sheet 209733



Part No: 646.3411

Job Qty: 12 pcs

Part Name: RH Wiper Deflector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/7/20

Job Tracking No:

Due Date: 6/8/20

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV N/C SHEET 1 IPP REV:A NEW ISSUE 13/02/21 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs		5/26/20	0.00	2.00	Bandsaw - 1		20-05-12
110	HAAS 4 Axis - B4B	12 pcs		5/27/20	1.00	20.41	HAAS - 1 - B4B		20-05-13 J.C.L.
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	12 pcs		5/27/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		20-05-17 J.C.L.
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S277670



Part: 646.3411

Job No: 209733

Serial No/Batch: S277670

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/13/20

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					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
130	QC 8	12 pcs	5/27/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	DAS 23
					QC 8 - 23	9-89 20/5/22
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
140	Outsource - 4 - Anodize	12 pcs	6/8/20		ATG001-VC	8 2020-05-22
150	Packaging 2-1 - Receive - B4B	12 pcs	6/8/20	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 -	

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5/7/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	DAS
						QC 5 - 61	JUN 02 2020 40
						QC 5 - 81	9-89
						QC 5 - 82	
						Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
180 Packaging 3-1 - Stock - B4B	12 pcs	6/8/20	0.00	0.00		Packaging 3 - 5 - B4B	DAS
						Packaging 3 - 6 - B4B	28
						Packaging 3 - 7 - B4B	9-89
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	

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[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
190 QC 21 - SA	12 pcs	6/8/20	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	JUN 04 2020 DAS
					QC 21 - SA - 53	70

Part Op 100 - (Bandsaw) Cut Blank at 7.125"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB151 DWG REV: N/C FOLIO REV: AA 9-89
 deburr and break all sharp edges
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - Issue P/O to ATG : 46477 1- Hard Anodize, Color Black and Prime as per Dwg 646.3400
 150 - (Receive & Inspect for Damage & Mat'l Certs)
 155 - (QC5- Inspect part completeness to step on W/O)
 180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S4.000X3.000	7075-T6S Sheet 4.000" Thick X 3.000" Wide	7.1280 ft (.594 ea)	100-Bandsaw - 1	5029879 (4 parts) FM136800 (1 part)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S4.000X3.000	7	15	0

53.000 x 04.000 B.P

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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wiper Deflector, RH	3.950inches $\pm$ 0.010	3.960 3.940		3.95
2	Wiper Deflector, RH	5.050inches $\pm$ 0.010	5.060 5.040		5.05
3	Wiper Deflector, RH	70.000Degrees $\pm$ 0.500	70.500 69.500	Angle	70
4	Wiper Deflector, RH	40.000Degrees $\pm$ 0.500	40.500 39.500	Angle	40
5	Wiper Deflector, RH	0.500inches $\pm$ 0.010	0.510 0.490	Radius	.500
6	Wiper Deflector, RH	0.250inches $\pm$ 0.010	0.260 0.240		.250
7	Wiper Deflector, RH	1.100inches $\pm$ 0.010	1.110 1.090		1.100
8	Wiper Deflector, RH	0.310inches $\pm$ 0.010	0.320 0.300		.312
9	Wiper Deflector, RH	45.000inches $\pm$ 0.500	45.500 44.500		45
10	Wiper Deflector, RH	0.190inches $\pm$ 0.010	0.200 0.180	Radius	.188
11	Wiper Deflector, RH	6.880inches $\pm$ 0.010	6.890 6.870		6.88
12	Wiper Deflector, RH	6.250inches $\pm$ 0.010	6.260 6.240		6.250
13	Wiper Deflector, RH	5.740inches $\pm$ 0.010	5.750 5.730		5.740
14	Wiper Deflector, RH	4.630inches $\pm$ 0.010	4.640 4.620		4.630
15	Wiper Deflector, RH	0.500inches $\pm$ 0.010	0.510 0.490	Radius	.500
16	Wiper Deflector, RH	1.630inches $\pm$ 0.010	1.640 1.620		1.630
17	Wiper Deflector, RH	3.000inches $\pm$ 0.010	3.010 2.990		3.000
18	Wiper Deflector, RH	30.000Degrees $\pm$ 0.500	30.500 29.500	Angle	30
19	Wiper Deflector, RH	0.190inches $\pm$ 0.010	0.200 0.180	Radius	.188
20	Wiper Deflector, RH	0.750inches $\pm$ 0.010	0.760 0.740		.751
21	Wiper Deflector, RH	2.750inches $\pm$ 0.010	2.760 2.740		2.750
22	Wiper Deflector, RH	0 $\pm$ 0			
23	Wiper Deflector, RH	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	45°
24	Wiper Deflector, RH	0.380inches $\pm$ 0.010	0.390 0.370		.380

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality	DEPARTMENT/PROCESS	Date: _____ Sequence #: _____ QTY Affected: _____ MRB (QS1042)
Description Work Order Deviation		Disposition	
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY	
Completed By		QC / QA Coordinator	
Lead hand / Supervisor		Other/Details:	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046477



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046477
PO Date: 5/22/20
Due Date: 5/29/20
Purchase Order Revision:
Revision Date:
Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	209338	500-706014-001	500-706014 REV.IR	Fitting, Boom to Nozzle -Issue P/O -ANODIZE COLOR BLACK, PER MIL-A-8625 TYPE 2 CLASS 2 -Material type; 6061-T6 -Certificate of Conformity is required	Firmed X3	-	5/29/20	3 pcs	0 pcs	3 pcs	\$11.40/pcs	\$34.20
2	209733	646.3411	646.3400 Rev N/C	RH Wiper Deflector : Various STC's Issue P/O to ATG : 1- Hard Anodize, Color Black and Prime as per Dwg 646.3400	Firmed X7 X3	-	5/29/20	7 pcs	0 pcs	7 pcs	\$15.16/pcs	\$106.12
	209840				Firmed	-	5/30/20	3 pcs	0 pcs	3 pcs	\$15.16/pcs	\$45.48
Sub Total:										10		\$151.60

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PURCHASE ORDER

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Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	209907	500-302037-001	500-302037 REV.IR	Support, Main Shaft -Issue P/O : -ANODIZE COLOR BLACK, PER MIL-A-8625 TYPE 2 CLASS 2, -Material; 6061T6 -Certificate of Conformity is required	Firmed	-	5/29/20	6 pcs	0 pcs	6 pcs	\$11.40/pcs	\$68.40
4	209946	500-302009-001	500-302009 REV.B	Bracket, Barrel Lock -Issue P/O : -ANODIZE COLOR BLACK, PER MIL-A-8625 TYPE 2 CLASS 2, -Material; 7075T6 -Certificate of Conformity is required	Firmed	-	5/29/20	1 pcs	0 pcs	1 pcs	\$11.40/pcs	\$11.40
5	209992	500-302022-001	500-302022 REV.A	Stop Block, LWR, Rotational -Issue P/O : -ANODIZE COLOR BLACK, PER MIL-A-8625 TYPE 2 CLASS 2, -Material; 6061T6 -Certificate of Conformity is required	Firmed	-	5/29/20	3 pcs	0 pcs	3 pcs	\$11.40/pcs	\$34.20

MAY 26 2020

MAY 26 2020



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada
Tel (613) 632-5200

PURCHASE ORDER

POHB046477



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	209957	500-302018-001	500-302018 REV.IR	Bracket, Adjustment, Actuator -Issue P/O : -ANODIZE COLOR BLACK, PER MIL-A-8625 TYPE 2 CLASS 2, -Material; 6061T6 -Certificate of Conformity is required	Firmed x3	-	5/29/20	3 pcs	0 pcs	3 pcs	\$11.40/pcs	\$34.20
									MAY 26 2020			
7	209997	D5155-043	D5155 Rev B	Co-Pilot Collective Head Assembly (212/412) : Various STC's Anodize Black as per Dwg D5155 Rev. B	Firmed x2	-	5/29/20	2 pcs	0 pcs	2 pcs	\$11.40/pcs	\$22.80
									MAY 26 2020			
Grand Total:												\$356.80

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920213

Date: 27-May-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 646.3411 Rev: NC RH Wiper Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5265778 Expiry Date: 08/21 Job: 27550 Line: 2 PO: POHB046477		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAY 27 2020</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

DAS
40
9-39

RECEIVED

MAY 27 2020

DART AEROSPACE LTD.

Made in Canada.